

BLUE

Dart Aerospace Ltd.

Date: Tuesday, 14/10/2008 1:10:28 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION  
 Job Number : 42568  
 Estimate Number : 10326  
 P.O. Number :  
 This Issue : 14/10/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D27317  
 Drawing Number : D2731 REV B -BLUE  
 Project Number : N/A  
 First Issue : / / Type : MACHINED PARTS Drawing Revision :  
 Material :  
 Previous Run : 41720 Due Date : 31/10/2008 Qty: 16 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08.10.14  
 Comment : Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 1.1474 f(s)

Lug Extrusion D2423

Batch: B33310 C L0810116

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 extrusion to .82"

Batch: \_\_\_\_\_

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

PG



Issue PO. 7383

Motec



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio D2731-7.

2-Check for crack while loading into the machine.

3-Tumble

4-Deburr any rough edges after tumbling

Machine per drawing D2731 Rev. B

C L0810116

(K6)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Receive + inspect for transit damage  
 Ensure C/C attached



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK

QCS



Inspect level 5



Comment: SECOND CHECK

S 06/10/25 (x16)

Date: Tuesday, 14/10/2008 1:10:28 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG EXTRUSION

Job Number: 42568

Part Number: D27317

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

gsl

08-10-30 (x16)

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B109083

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109816

ml 08 10 10 (16)

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

25 08-11-11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

P-294/11 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/12 (16)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-11-11

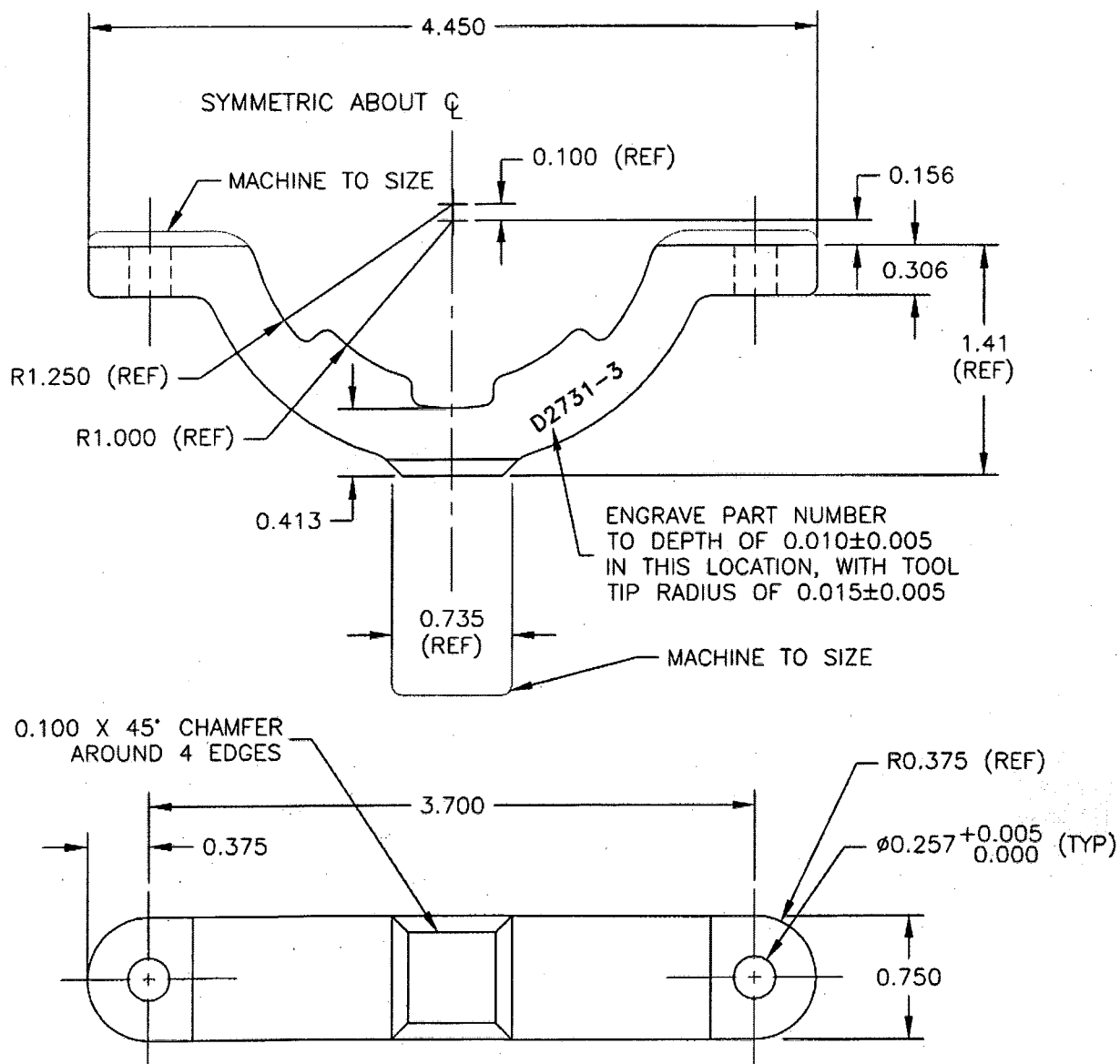






DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
99.07.14 KE



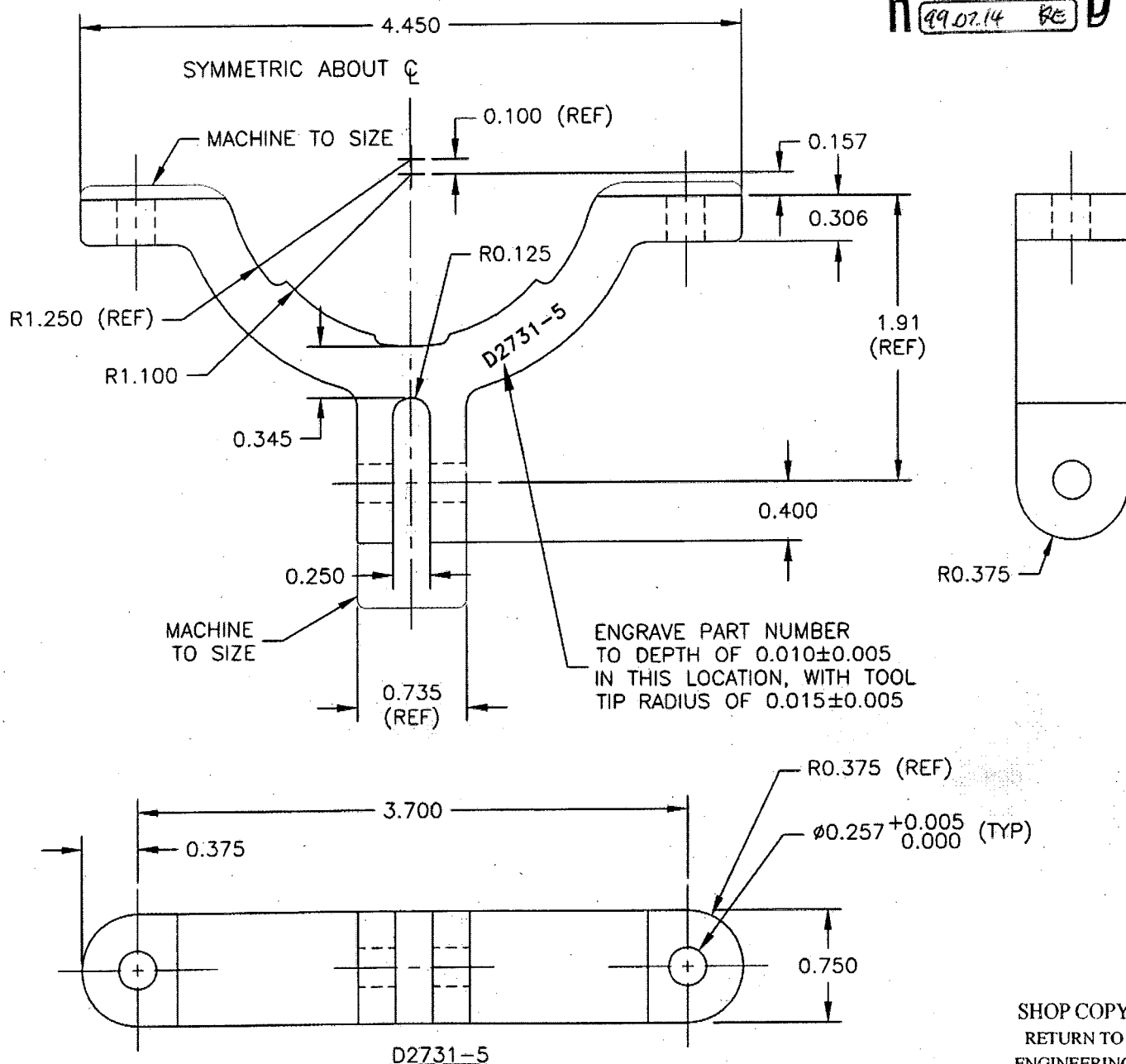
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42568



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 3 OF 4
DATE 99.07.06	TITLE MOUNTING LUG		SCALE 1:1

**RELEASED**  
99.07.14 *RE*



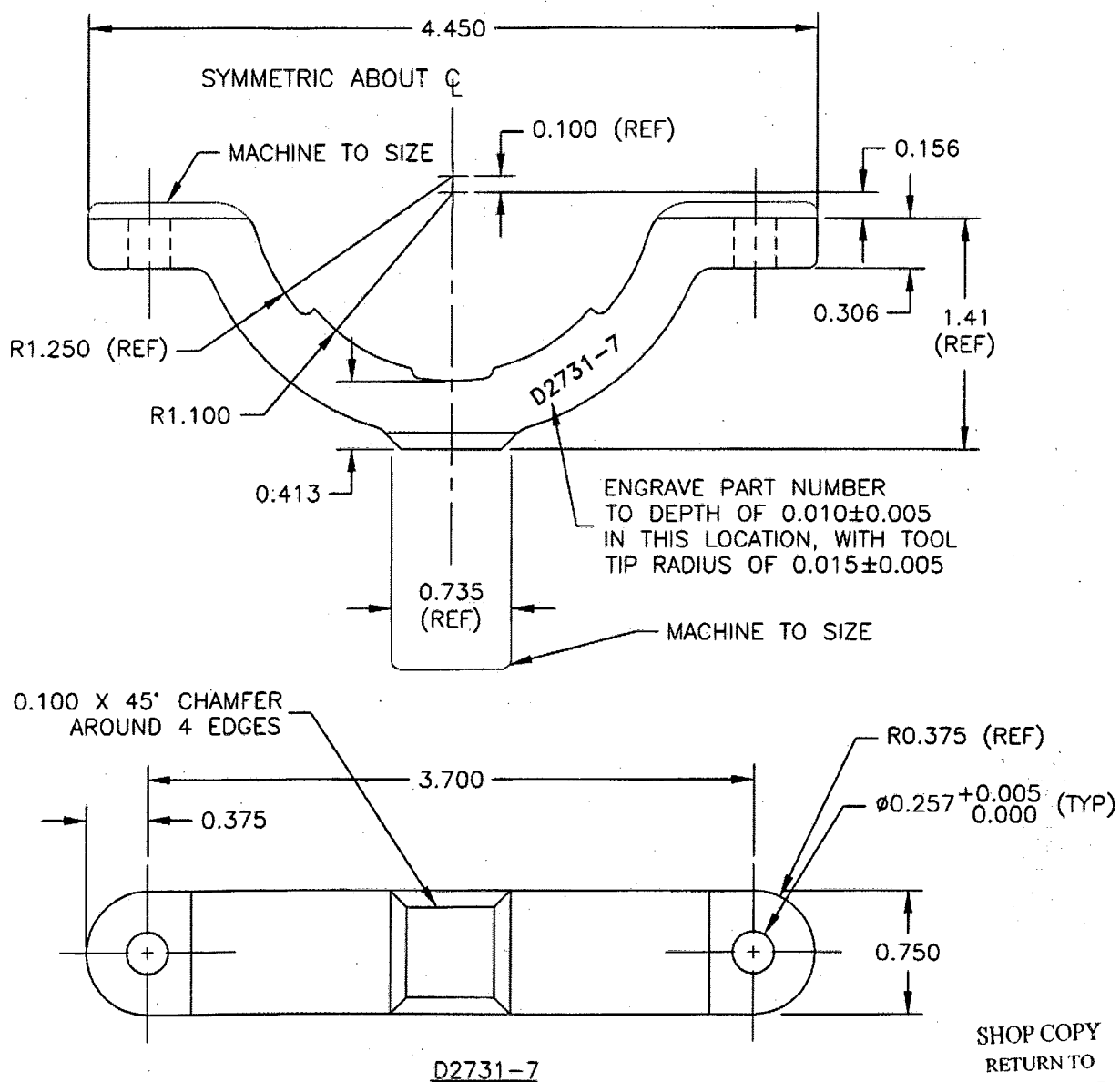
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *42568*



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
99.07.14 *KE*



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *42508*



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>MATERIAL BATCH NUMBER</u>	<u>P.O. NUMBER</u>
16	2731-7	Lug	D2423 B33310	7383
19	3394-3	Lug	D2423 B33310	7383

MATERIAL: supplied by DART

S 08/10/29

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Denise Robinson

Vankleek Hill, October 28, 2008